



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3791-1**Job Sheet 197396****Part No:** D3791-1**Job Qty:** 10 pcs**Part Name:** Wearpad**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/5/19**Job Tracking No:****Due Date:** 7/26/19**Created By:** Jason Leroux**Type:** Stock**Description:**

Note: DWG D3791 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-22 revA as per dwg
ECN1191 DD verified by:EC IPP REV:C 18.11.09 AS PERR DWG REV.B DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	10 pcs		7/26/19	0.17	0.82	Waterjet - Flow			02/19/07/31
110	QC 2	10 pcs		7/26/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			02/19/07/31
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

**Container No:** S201871**Part:** D3791-1**Job No:** 197396**Serial No/Batch:** S201871**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/12/19

Plex 7/5/19 1:25 PM dart.leroux.jason

120 QC 8	10 pcs	7/26/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	10 pcs	7/26/19	0.25 0.25	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	AUG 7 2019
				Small Fab - Brake - 3 - B4B	
140 QC 5	10 pcs	7/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
150 Automated Welding - B4B	10 pcs	7/26/19	0.00 3.41	Automated Welding - 1 - B4B	
160 QC 10	10 pcs	7/26/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	

Plex 7/5/19 1:25 PM dart.leroux.jason

170 QC 5	10 pcs	7/26/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	2
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	62
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Spray Paint - 2 - B4B	10 pcs	7/26/19	0.00 0.17	Spray Paint - 1 - B4B	19-8-12
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 3	10 pcs	7/26/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
200 Packaging 3-1 - Stock - B4B	10 pcs	7/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002 H 14-8-12
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	7/26/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - 1-Cut as per Dwg D3791 Dwg Rev: B Prog Rev: B 2-Deburr if necessary AUG 15 2019
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Form as per dwg) 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs
140 - (QC5- Inspect part completeness to step on W/O) Ensure joggle as per dwg D3429
150 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1-WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M138901
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
180 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: 5200412
190 - (QC3- Inspect Part Finish)
200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	2.9170 sf (.2917 ea)	100-Waterjet - Flow - 1	5179460

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	3	136	0

Part Specifications	
Specifications could not be found.	

Plex 7/5/19 1:25 PM dart.leroux.jason

DART AEROSPACE LTD		Work Order:	197396
Description: Wearplate		Part Number:	D3791-1
Inspection Dwg: D3791 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.220	+/-0.010	.219	1			
0.435	+/-0.010	.436	1			
1.97	+/-0.030	1.97	1			
2.260	+/-0.010	2.261	1			
3.63	+/-0.030	3.63	1			
0.38	+/-0.030	.38	1			
3.4	+/-0.100	3.4	1			
8.0	+/-0.030	8.0	1			
14.07	+/-0.030	14.07	1			
14.82	+/-0.030	14.82	1			
0.063	+/-0.010	.057	1			
0.75	+/-0.030	.75	1			
0.435	+/-0.010	.435	1			
Ø0.188	+/-0.010	Ø.189	1			

Measured by:	DC	Audited by:	DAS 81	Prototype Approval:	N/A
Date:	19/07/31	Date:	9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	
B	19.06.11	Drawing revision and dimensions updated	MG	



Container No: S201871



Part: D3791 - 1

Job No: 197396

Serial No/Batch: S201871

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 07/31/19